



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3013

Job Sheet 187495



Part No: 646.3013

Job Qty: 20 ea

Part Name: Blade



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/5/18

Job Tracking No:

Due Date: 1/22/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV N/C SHEET 10 IPP REV:A NEW ISSUE 12/11/09 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		1/22/19	0.00	0.00	Start Up Machining-1		mmc 19/01/08
100	Bandsaw	20 pcs		1/22/19	0.00	0.35	Bandsaw1		11
110	CNC Vertical Machining	20 pcs		1/22/19	0.13	18.08	HAAS1-1		mmc 19/01/08
120	QC	20 pcs		1/22/19	0.00	0.00	QC2 Machining-1		" "
130	QC	20 pcs		1/22/19	0.00	0.00	QC8 Machining-1		19-01-10
140	Outsource	20 pcs		1/22/19			MEI001-VC	5	EX 19-01-11
150	Packaging	20 pcs		1/22/19	0.00	0.00	Packaging2		JAN 22 2019
155	QC	20 pcs		1/22/19	0.00	0.00	QC6		38
160	SprayPaint	20 pcs		1/22/19	0.00	0.77	Spray Paint		A2 08-1-28
170	QC	20 pcs		1/22/19	0.00	0.00	QC14		11/02/2019
180	Packaging	20 pcs		1/22/19	0.00	0.00	Packaging3-1	STCK 101	17 MAR 05 2019
190	QC21-SA	20 Ea		1/22/19	0.00	0.00	QC21		MAR 06 2019

Part Op 100 - Cut Blank at 4.930"

Descriptions: 110 - 1-Machine per folio FB150 2- deburr and break all sharp edges except otherwise noted KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL BURRS ON CUTTING EDGE

140 - ISSUE P/O: _____ FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS As Per Dwg 646.3000 PART ARE MADE FROM AISI A2 TOOL STEEL

160 - PRIME AS PER DWG, SEE NOTE #4 PRIMER BATCH: 5147812

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	8.2200 ft (.411 ea)	90-Start up Operation	<u>5132658</u>

Allocations

Required	Inventory	Allocated
8	99	0



Container No: S141603



Part: 646.3013

Job No: 187495

Serial No/Batch: S141603

Revision:

Inspector:

Exp Date:

Instructions:

Date: 01/03/19

Plex 12/5/18 2:40 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION	DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐		
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐	Quality ☐	

Date :	Sequence #:	QTY Affected :	MRB (QSI042)
Description Work Order Deviation		Disposition	Completed By
			Lead hand / Supervisor
			QC / QA Coordinator

FAULT CATEGORY					
☐ Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong		
☐ Misaligned/off center	☐ BOM/Route	☐ Folio/Program	☐ Outside Tolerance		
☐ Broken/Damage/Defect	☐ Incomplete/Unclear Instructions	☐ Grain Direction	☐ Drawing		
☐ Shank/Ripple/Wave/Twist	☐ Drill Holes	☐ Weld	☐ Finish		
☐ Chatter	☐ Fit/Function	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
☐ Bled		☐ Out of Sequence	☐ Misread		
		☐ Off-set/Set-up			

ils:

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blade	0.375inches $\pm$ 0.005	0.380 0.370		
2	Blade	66.500Degrees $\pm$ 0.500	67.000 66.000	Angle	
3	Blade	0.177inches $\pm$ 0.005 - 0.001	0.182 0.176	Diameter	
4	Blade	4.800inches $\pm$ 0.010 - 0.001	4.810 4.799		
5	Blade	4.396inches $\pm$ 0.005	4.401 4.391		
6	Blade	0.576inches $\pm$ 0.005	0.581 0.571		
7	Blade	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	
8	Blade	0.635inches $\pm$ 0.002	0.637 0.633		
9	Blade	1.109inches $\pm$ 0.002	1.111 1.107		
10	Blade	0.240inches $\pm$ 0.002	0.242 0.238		
11	Blade	0.576inches $\pm$ 0.005	0.581 0.571		
12	Blade	0.940inches $\pm$ 0.010	0.950 0.930		
13	Blade	0.125inches $\pm$ 0.005	0.130 0.120	Radius	
14	Blade	60.000Degrees $\pm$ 0.500	60.500 59.500	Angle	
15	Blade	0.325inches $\pm$ 0.005	0.330 0.320		
16	Blade	30.000Degrees $\pm$ 0.000	30.000 30.000	Angle	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

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Other/Details: _____																																																	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042230



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO042230
PO Date: 1/10/19
Due Date: 2/1/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186717	646.3015	Blade FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS As per dwg 646.3000 PART ARE MADE FROM AISI A2 TOOL STEEL DETAIL OF C OF C REQUIRED	Firmed	-	2/1/19	46 pcs	0 pcs	46 pcs	\$4.9090909/pcs	\$225.82
2	187495	646.3013	Blade ISSUE P/O: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS As Per Dwg 646.3000 PART ARE MADE FROM AISI A2 TOOL STEEL	Firmed	-	2/1/19	20 pcs	0 pcs	20 pcs	\$4.9090909/pcs	\$98.18

Grand Total: \$324.00

DAS
38
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042230



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/10/19 1:16 PM dart.tsimiklis.chrisoula

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
333268	1	133972

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
042230 ✓		A2	2019/1/11	CLIENT

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
66	646,3015 & 646,3013	BLADES	JOB # 186717 & 187495	26,

1 BOITE DE CARTON EPS

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BC EPS	1	

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 66

POIDS EXPÉDIÉ / Weight Shipped : 26,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

APPROUVÉ

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 66

POIDS EXPÉDIÉ / Weight Shipped : 26,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2019/01/21

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
333268	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
042230 ✓	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	11	59 - 61 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
66	26	646,3015 & 646,3013 BLADES ✓ 46 x ✓ 20 x JOB # 186717 & 187495 1 BOITE DE CARTON EPS

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2019-01-20

Pierre Piché
Chief Inspector



APPROUVÉ